

Date: Tuesday, 4/17/2007 11:09:53 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 31852		
Estimate Number	: 10467		
P.O. Number	: N/A	Part Number	: D3391021
This Issue	: 4/17/2007 S.O. No. : N/A	Drawing Number	: D3391 REV.F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 31851	Material	: N/A
Written By	:	Due Date	: 5/20/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>4/07.04.17</u>		
Comment	: Est. A 05.09.13 New issue KJJ/JLM		
	: Est. B 06.02.10 Dwg rev.D ecn 773 EC		
	: Est. C 06.05.02 Added inspections EC		
	: est D 07.03.13 rev F dwg EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6013047	SKIDTUBE MAT'L
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	<u>B 26547 BE 07-04-19</u>

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1  
 Cut extrusion to 46.52 +0.010 -0.020

BE 07-04-19

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: No bender  
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-5-7

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-8

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. F  
 Identify as D3391-1

2-Deburr

J.F. 07/05/16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31852

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/16

①

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

SG 07.05.22

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG 07.05.22

①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/05/22

①

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr

7-5-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-205-250

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

7-6-1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31852

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M/L 07/07/19* ①

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 104144*

*BR/M/L 07-07-19* ②

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 07/07/19* ①

16.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

*M102849*

*AL 07-07-19* ③

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

*AL 07-07-19* ④

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Em 07/07/20* ⑤

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

*B31346*

*AL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31852

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

B 31398

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET

B 32744

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Bolt  
Pick:

Qty	Part Number	Description	Batch
4	AN3C4A	Bolt	M 104955

M 104955

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3L	Washer	M 104603

M 104603

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
washer

M 104863

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Install tow Cap as per Dwg D3391  
Identify as D3391-021

M 104863

07-07-23

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inspect thread of each insert using DT8821

07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/07/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 4/17/2007 11:09:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31852

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPD B33441 6/7/7/30

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①

Job Completion



u 6/7/7/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

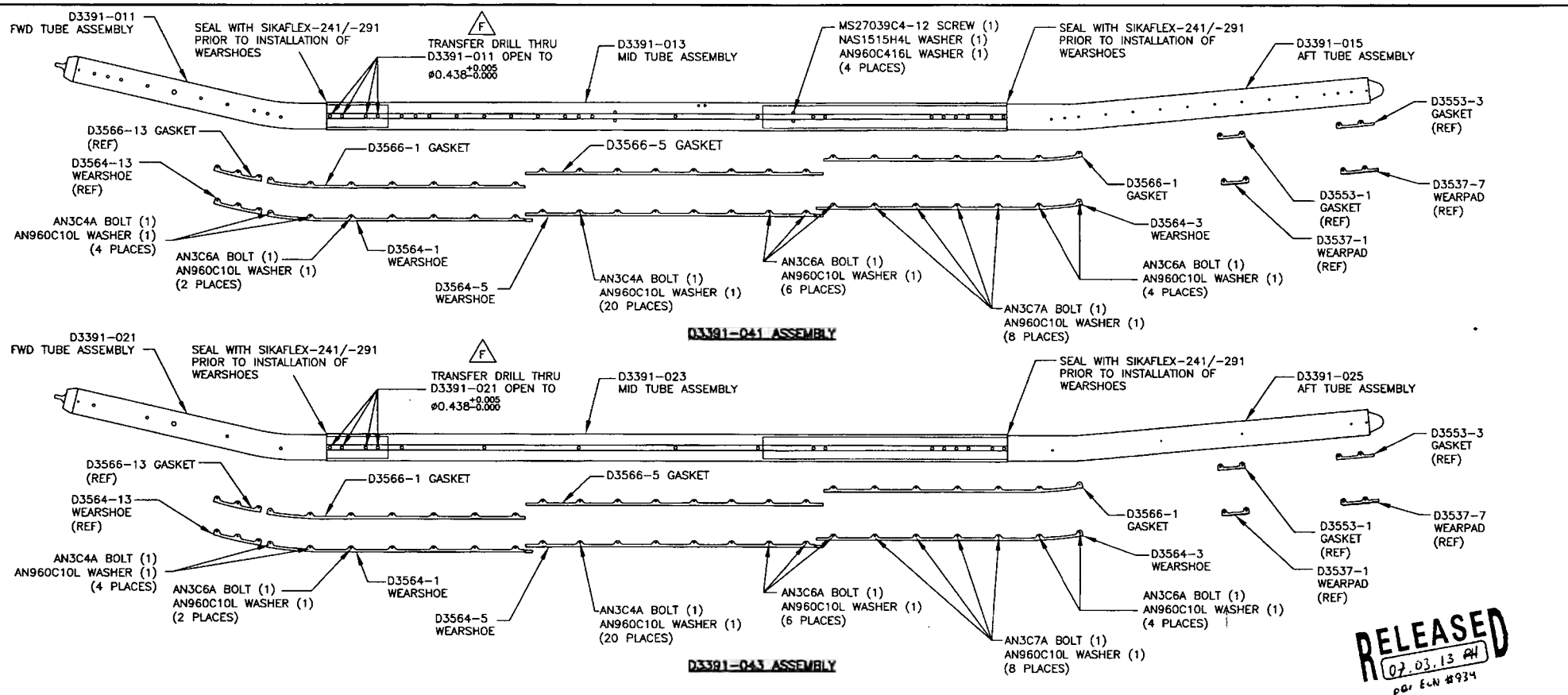
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

#### GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391/Ø0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

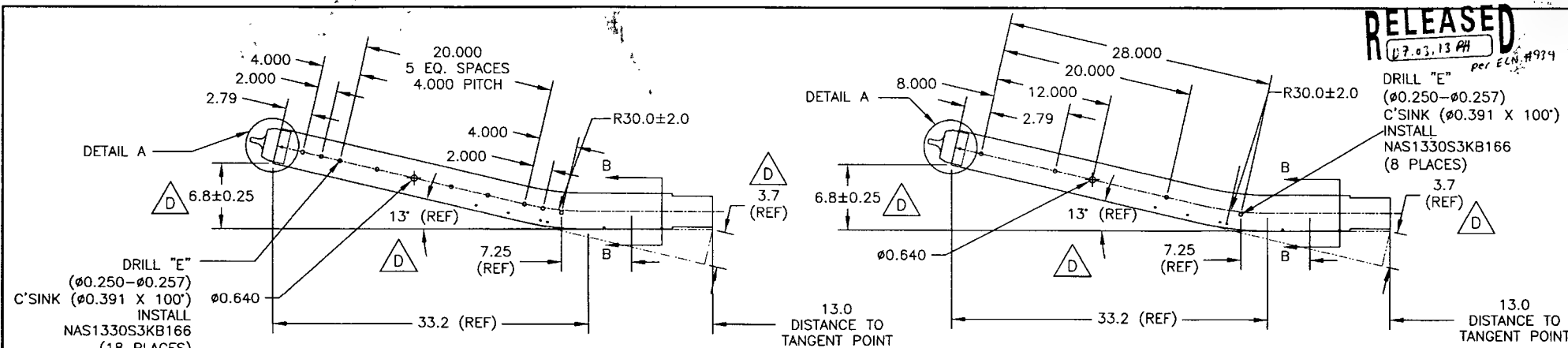
Copyright © 2005 BY DART Aerospace USA, Inc.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART Aerospace USA, Inc.

F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART Aerospace USA, Inc. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D3391
DATE	TITLE	SCALE
07.01.18	412 FLOAT SKIDTUBE	NTS

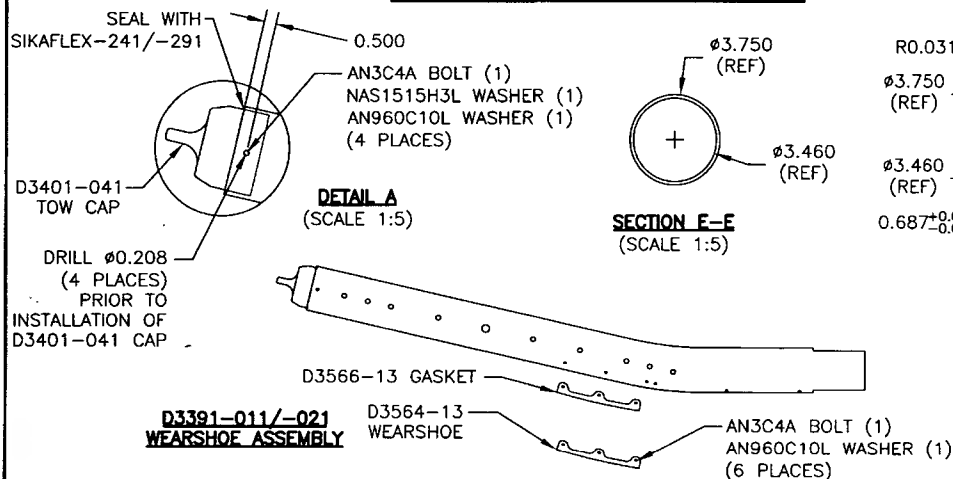
RELEASED  
07.03.13 AH  
per EUN #934

**RELEASED**  
 07.03.13 AH  
 per ECR #934



**D3391-011 ASSEMBLY AND BENDING DETAIL**

**D3391-021 ASSEMBLY AND BENDING DETAIL**



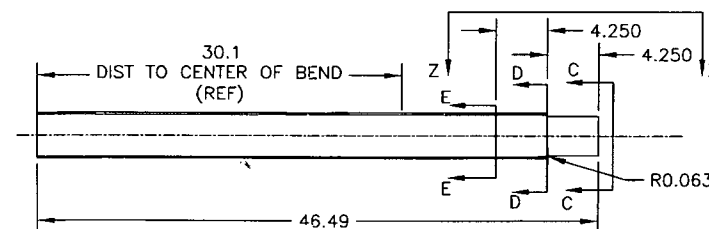
**D3391-011/-021 WEARSHOE ASSEMBLY**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5  
 DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100")  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

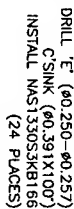
**SECTION B-B (SCALE 1:5)**



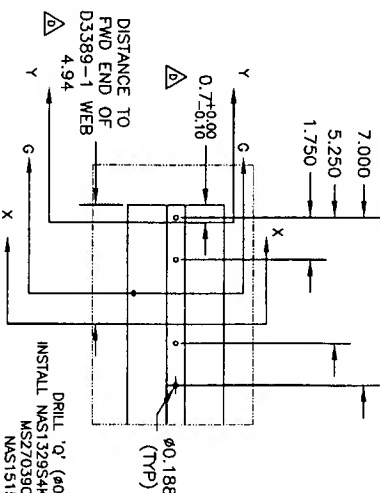
**D3391-1 DRILLING AND CUTTING DETAIL**  
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.		DESIGN PH	DRAWN BY AH	DART AEROSPACE USA, INC. PORT HADLOCK, MA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391	REV. F SHEET 2 OF 5
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:10	

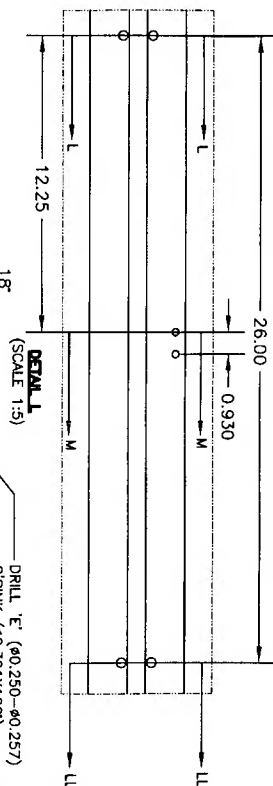
NO. 21852  
 WORK ORDER  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 RETURN TO  
 SHOP COPY  
 ENGINEERING



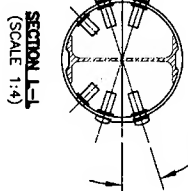
**03391-013 ASSEMBLY DETAIL**



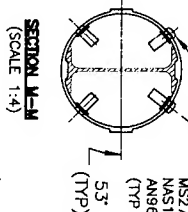
(SCALE 1:5)



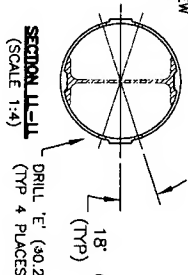
**(SCALE 1:5)**



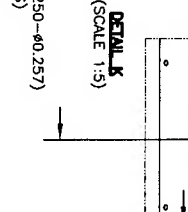
**SECTION 1-1**  
**(SCALE 1:4)**



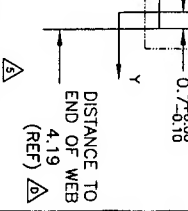
**SECTION M-**  
(SCALE 1:4)



**SECTION 11-1**  
(SCALE 1:4)



(i) 150-00.257



12391-013/-023 MID TUBE ASSEMBLY PARTS LIST			
QTY -	QTY -	PART NUMBER	DESCRIPTION
013	023		
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2600-1-1T00	EXTRUSION
1	1	D3388-1	WEB
24	20	NAS1330S3K8T16	INSERT (OR NAS1330C3K8T16)
24	10	NAS1330S3K8T6	INSERT (OR NAS1330C3K8T6)
4		NAS1329S4K8T140	INSERT (OR NAS1329C3K8T140)
4		NAS1515H3L	WASHER
4		AN860C10L	WASHER
4		NAS1515H4L	WASHER
4		AN860C4T6L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-06	SCREW

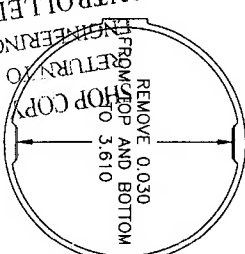
**03691-013/-023 MID TUBE ASSEMBLY PARTS LIST**

**D3391-013/-023 MID TUBE ASSEMBLY**

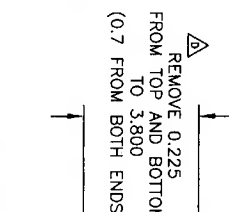
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 0155

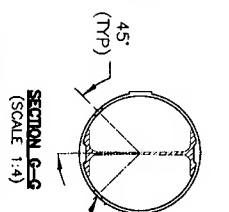
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
31852  
NO



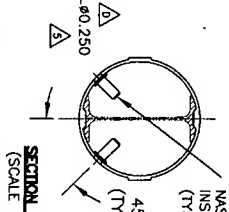
**SECTION X-X**  
(SCALE 1:2)



**SECTION Y-3**  
(SCALE 1:4)




**SECTION C-3**  
(SCALE 1:4)



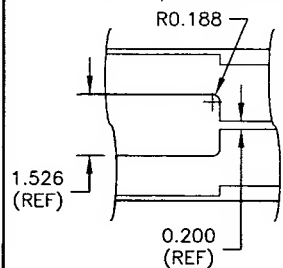
**SECTION H**  
**(SCALE 1:1)**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

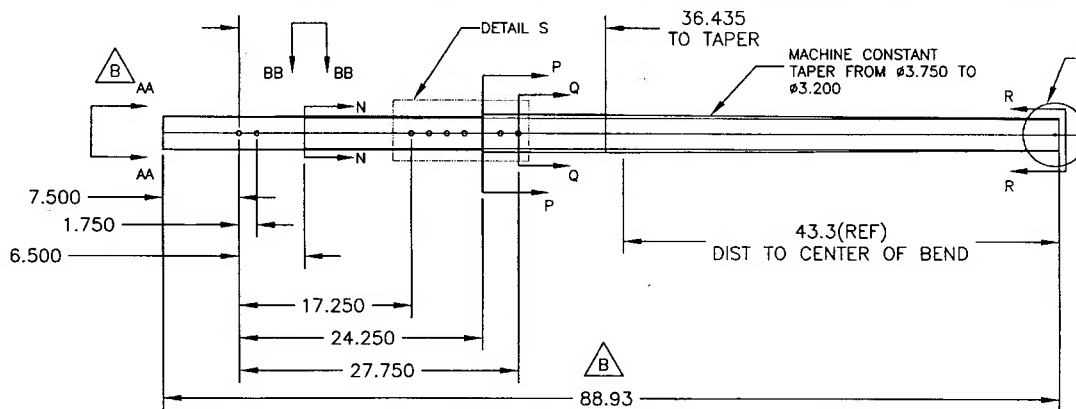
DESIGN <i>PH</i>		DRAWN BY <i>PH</i>		 <b>DART AEROSPACE USA, INC.</b> DART MILWAUKEE, WI	
CHECKED <del><i>PH</i></del>	APPROVED <del><i>PH</i></del>	DRAWING NO. D3391		REV. F. 3 SHEET 3 OF 5	
DATE 07/01/18	TITLE 412 FLOAT SKIDTUBE		SCALE 1:20		

08661-023 / 5551111 DETAIL

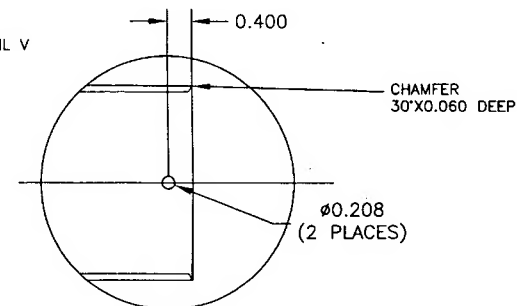
RELEASED  
07.05.13 PM  
PCL EUN #934



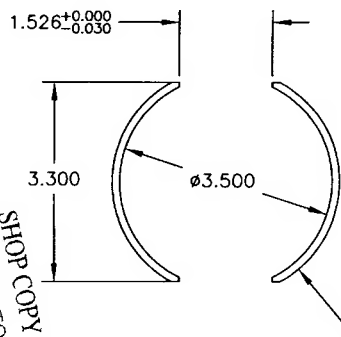
VIEW BB-BB  
(SCALE 1:3)



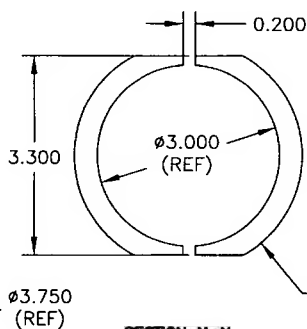
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



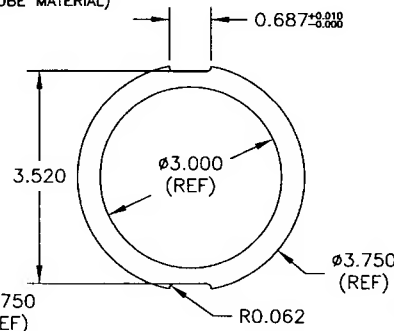
DETAIL V  
(SCALE 1:2)



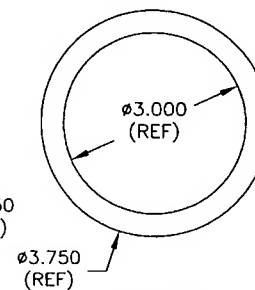
SECTION AA-AA  
(SCALE 1:2)



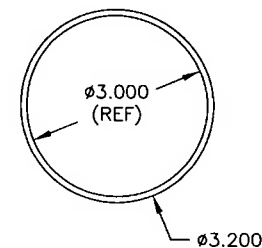
SECTION N-N  
(SCALE 1:2)



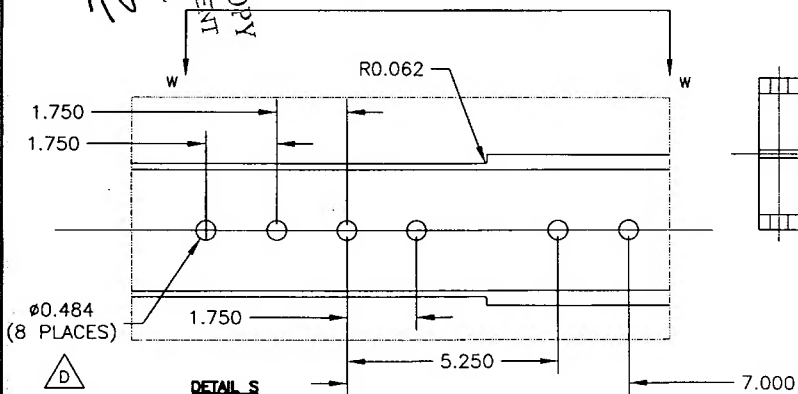
SECTION P-P  
(SCALE 1:2)



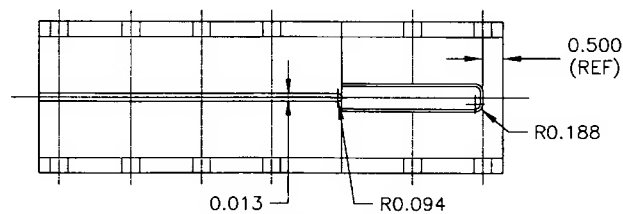
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

RELEASED  
07-03-13 PH  
per ECN #934

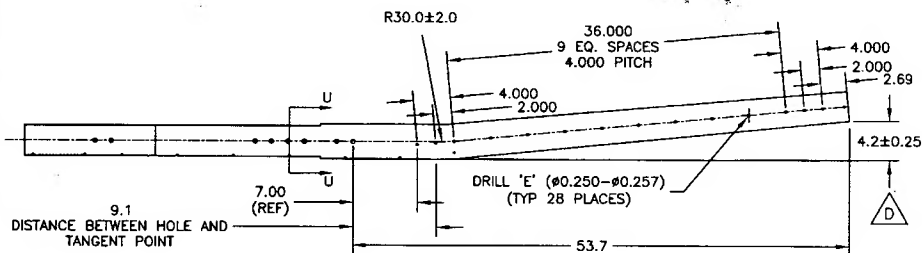
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

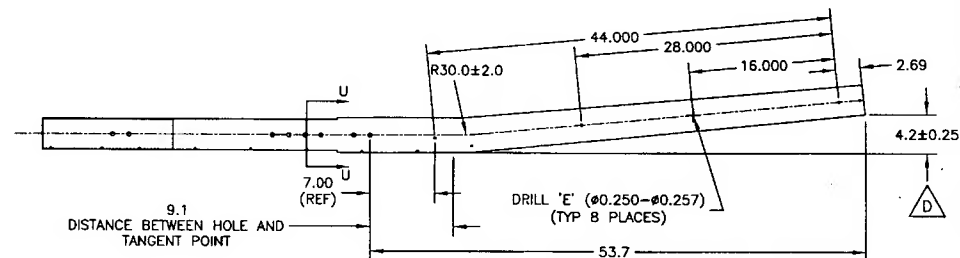
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. FORT WALDOCK, WA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



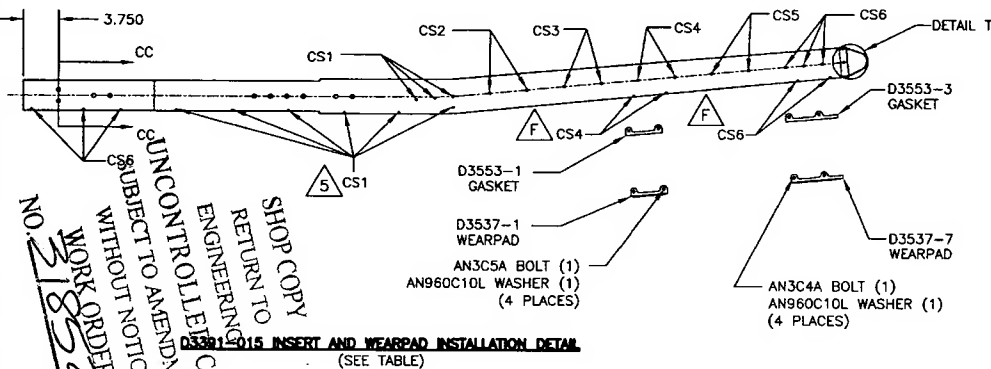




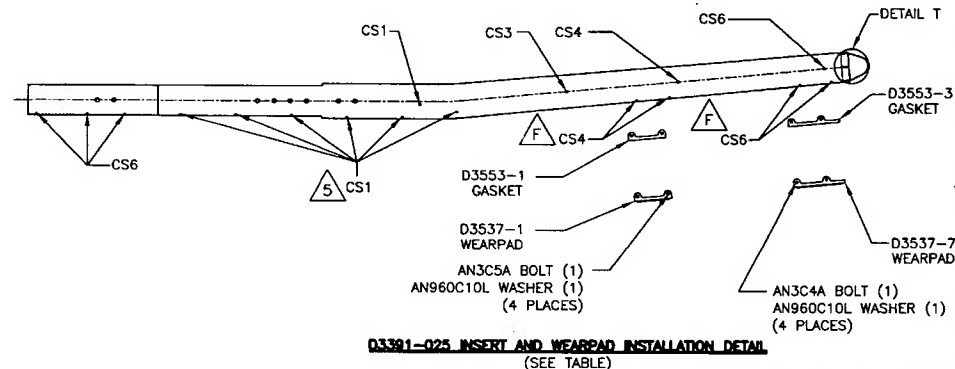
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



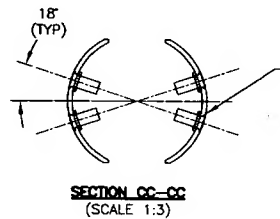
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL (SEE TABLE)



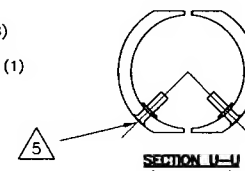
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL (SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	2	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	2	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



AN3C4A BOLT (1)  
NAS1515H3L WASHER (1)  
AN960C10L WASHER (1)  
(2 PLACES)  
DETAIL T (SCALE 1:3)  
D2646 AFT CAP  
SEAL WITH SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4	2	Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4	2	Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DESIGN RH	DRAWN BY BL	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED H	APPROVED H	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

RELEASED  
07.03.13 RH  
per ECN #934